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Dart Aerospace Ltd.
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D2512
Job Sheet 207123



Part No: D2512

Job Qty: 1 pcs

Part Name: Basket Lid



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/19/20

Job Tracking No:

Due Date: 3/30/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV H Rev IPP:M03.01.31 AddedD2012-117forD130-701-041 KJ/RF IPP Rev:N 06.04.05 Added level21
EC IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM VERIFIED BY:DD IPP Rev:P 08-
08-29 revE as per dwg DD verified by:EC IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified
by:EC IPP Rev:R 10.06.29 added pressure wash DD verf:EC IPP REV:S 12.07.27 AS PER DWG REV.F DD
VERF:EC IPP REV:T 12.08.08 AS PER DWG REV.G DD VERF:EC IPP REV:U 16.11.03 AS PER DWG REV.H
DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	1 pcs	3/30/20		0.00	16.95	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs	3/30/20		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
					0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		



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Container No: S259937



Part: D2512

Job No: 207123

Serial No/Batch: S259937

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/02/20

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						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
125 Handfinish - 2-1 Pressure- B4B	1 pcs	3/30/20	0.00	0.50	Handfinish - 2 - 1 - B4B		BEB 20-03-12
					Handfinish - 2 - 2 - B4B		
					Handfinish - 2 - 3 - B4B		
					Handfinish - 2 - 4 - B4B		
130 Powdercoat - 1 White Gl(A)- B4B	1 pcs	3/30/20	0.00	0.77	Powdercoat - 1 - B4B		
					Powdercoat - 2 - B4B		
					Powdercoat - 3 - B4B		20-03-12
					Powdercoat - 4 - B4B		
140 Handfinish - 3-1- WingWalk- B4B	1 pcs	3/30/20	0.00	1.35	Handfinish - 3 - 1 - B4B		ML 20-3-13
					Handfinish - 3 - 2 - B4B		
					Handfinish - 3 - 3 - B4B		
					Handfinish - 3 - 4 - B4B		
					Handfinish - 3 - 5 - B4B		
150 QC 3	1 pcs	3/30/20	0.00	0.00	QC 3 - 10		
					QC 3 - 13		
					QC 3 - 15		
					QC 3 - 17		
					QC 3 - 18		
					QC 3 - 2		
					QC 3 - 28		
					QC 3 - 3		
					QC 3 - 30		
					QC 3 - 34		
					QC 3 - 36		
					QC 3 - 41		
					QC 3 - 51		
					QC 3 - 58		
					QC 3 - 59		BEB 20-03-16
					QC 3 - 68		
					QC 3 - 9		
					QC 3 - 40		
					QC 3 - 19		
					QC 3 - 43		
					QC 3 - 24		
					QC 3 - 61		
					QC 3 - 81		
					QC 3 - 82		
160 Packaging 3-1 - Stock - B4B	1 pcs	3/30/20	0.00	0.00	Packaging 3 - 1 - B4B		ML 20-3-14
					Packaging 3 - 2 - B4B		
					Packaging 3 - 3 - B4B		
					Packaging 3 - 4 - B4B		

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				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
170 QC 21 - SA	1	3/30/20	0.00 0.00	QC 21 - SA - 21	APR 16 2020
	pcs			QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: 313620) - Weld ribs as per Dwg D2512 using Welding Jig DT 9436 2- WELD
 Descriptions: MESH AND REMOVE SECTIONS OF MESH WHERE INDICATED AS PER DWG

110 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O)

125 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings)

130 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum)- Plug all holes prior to Powdercoat START TIME: 11:25

FINISH TIME: 3:50 START TIME: 11:40 11:25590

140 - (Wing Walk as per dwg QSI005 4.4 Batch _____) Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4 Batch: _____

150 - (QC3- Inspect Part Finish)

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

M4#014688

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2232-1 ✓	Basket Hinge	2 pcs (2 ea) ✓	100-Large Fab - Welded Assy-1	<u>5237364</u>
D2236 ✓	Lid Rib	4 pcs (4 ea) ✓	100-Large Fab - Welded Assy-1	<u>5257707</u>
D2506 ✓	Label Plate ✓	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	<u>5072537</u>
D2512-3	Rib	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	<u>5232177</u>
D2512-5 ✓	Rib	6 pcs (6 ea) ✓	100-Large Fab - Welded Assy-1	<u>5257613</u>
D2512-7 ✓	Rib	3 pcs (3 ea) ✓	100-Large Fab - Welded Assy-1	<u>5257480</u>
D2581 ✓	Mounting Bracket	2 pcs (2 ea) ✓	100-Large Fab - Welded Assy-1	<u>5246180</u>
D3825-043 ✓	Rib Assembly (Basket End, Lid)	2 pcs (2 ea) ✓	100-Large Fab - Welded Assy-1	<u>5231988</u>
M304EX0.75-16F ✓	Expanded Metal Flat SS	32 sf (32 ea) ✓	100-Large Fab - Welded Assy-1	<u>5236300</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D2232-1	2	14	0
	D2236	4	4	0
	D2506	1	3	0
	D2512-3	2	6	0
	D2512-5	6	0	0
	D2512-7	3	0	0
	D2581	2	46	0
	D3825-043	2	4	0
	M304EX0.75-16F	32	594	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					